

Work Order ID 50355



Page 1

July 13, 2009 12:03:44 PM

Item ID: D3115-1 *GY*

Accept



Setup Start



Revision ID: B

Stop



Item Name: Bracket

Start Date: 7/15/09 Start Qty: 6.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 09-07-15 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

Operation Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3115

Rev B

100



FLOW WATER JET

Waterjet

Memo

0.00

M1 09 08 21 (6)

FLOW CNC Waterjet

1-Cut as per Dwg D3115 Dwg Rev: *B* Prog Rev: *B* 2-
Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

M1 09 08 21 (6)

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

⇒ SOR/08/21

(6) ↗

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50355



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Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

130



HandFinish

Hand Finishing

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

M 09/08/25 (6) Ø

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

BK 09-08-25 (6)

Memo

0.00

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME: 7:30AM OVEN TEMPERATURE:
320°F FINISH TIME: 8:00AM*M 09/08/26 (X6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50355

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July 13, 2009 12:03:44 PM

Item ID: D3115-1

Revision ID: B

Item Name: Bracket

Start Date: 7/15/09 Start Qty: 6.00

Accept



Setup Start



Stop



Required Date: 7/15/09 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

BL 09-08-26

⑥

170



Packaging

Packaging

Identify as per dwg & Stock Location: 60

0.00

R9/8/26 (E)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/08/26 (D)

BL 09-8-26 ⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 13, 2009 12:03:43 PM

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Work Order ID: 50355



Parent Item: D3115-1RevB



Parent Item Name: Bracket

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	163.2716	0.1408			

2024-T3 .063 sheet

Warehouse

Location

Main Warehouse

MAT	Loc Qty	Loc Code
102942	1.5	
105916	3.69	
106223	1.47	
109463	24.2	
110980	15.45	
111787	114.961579	
19059	2	

ML 09.08.2)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	50355
Description: BRACKET	Part Number:	D3115-1
Inspection Dwg: D3115 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

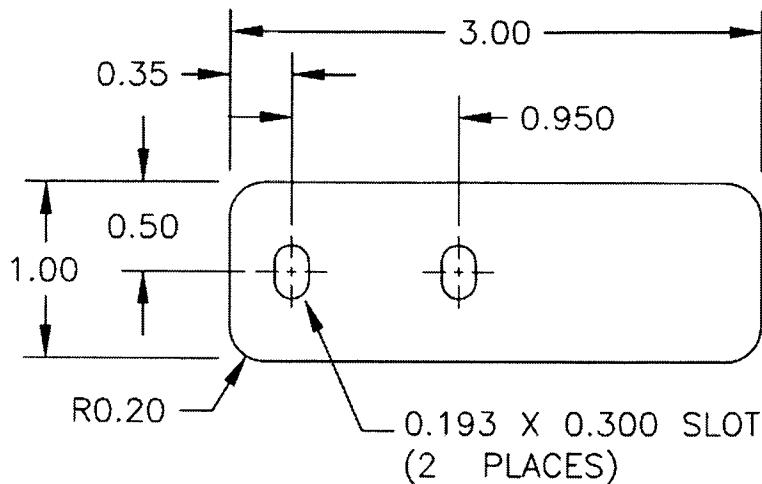
X First Article Prototype

Measured by:	<u>M. M</u>	Audited by:	<u>S</u>	Prototype Approval:	<u>1</u>
Date:	09/08/21	Date:	07/08/21	Date:	09

Rev	Date	Change	Revised by	Approved
A	...	New Issue	KJ/JLM	

DARTCOPY 185
DUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. B D3115 SHEET 1 OF 1
DATE		TITLE SCALE 04.10.18 BRACKET 1:1
A	02.04.12	NEW ISSUE
B	04.10.18	ADD PART MARKING

RELEASED
04.11.23 C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50355

MF - 09-07-15

D3115-1 BRACKETNOTES

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-233
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER